

Work Order ID 122704

122704

Page 1

Tuesday, July 22, 2014 8:44:12 AM

Item ID: D4775-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Strut Assembly 9

Start Date: 7/21/14 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1407-23 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00							
Packaging									

9 FF OCT 24 2014

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG								
	A/R PROSEAL BATCH: <u>128638</u>								
	2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)								

9 FF OCT 24 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122704***122704***

Page 2

Tuesday, July 22, 2014 8:44:13 AM

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 7/21/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/21/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

⑨ 14-10-24 ID

140

Identify as per dwg & Stock Location: ST 366 0.00***140***

Packaging

Memo

0.00

Packaging

9x 80 14-10-24

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

Quality Control

14/10/27 IDMF 14-10-24

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Picklist Print

Tuesday, July 22, 2014 8:44:12 AM

Page 1

Work Order ID: 122704

122704

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	52.0000	1	10			
										**	FF	OCT 2 4 2014	

Location	Loc Qty	Loc Code
GA 125592	32	
113361	10	
113841	1	
115177	20	
117205	1	
ST266	20	
116120	20	

D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	61.0000	1	10			
										**	FF	OCT 2 4 2014	

Location	Loc Qty	Loc Code
ST121	16	
121800	16	
ST121	45	
113699	1	
115995	28	
116963	16	

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Page 2

Tuesday, July 22, 2014 8:44:12 AM

Work Order ID: 122704

122704

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 10.00

Required Qty: 10.00

D4776-1

Manufactured No

110

Each

52.0000

1

10

D4776-1

Basket Strut Clevis

**

FF OCT 2 4 2014

LocationLoc QtyLoc Code

ST120

124238

52

110934

1

113290

1

115946

40

120234

10

6

3

D4776-5

Manufactured No

110

Each

243.0000

4

40

D4776-5

Spacer

**

FF OCT 2 4 2014

LocationLoc QtyLoc Code

ST120

122748

243

111095

3

112597

1

113369

31

116137

167

117247

1

*

121875

40

24

12

AN3-10A

Purchased No

110

Each

368.0000

2

20

AN3-10A

Bolt

**

FF OCT 2 4 2014

LocationLoc QtyLoc Code

ST351

68

m127817

35

m128403

33

ST511

300

m128813

150

m128936

150

118

Tuesday, July 22, 2014 8:44:12 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

Page 3

Tuesday, July 22, 2014 8:44:12 AM

Work Order ID: 122704

122704

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

110

Each

4,892.000

2

20

MS21042L3

FF

OCT 24 2014

Nut

Location

Loc Qty

Loc Code

ST307

4892

123900

955

M126333

34

M127410

13

M127831

41

M128401

42

M128754

3807

18

MS21209-F615

Purchased

No

110

Each

123.0000

1

10

MS21209-F615

FF

OCT 24 2014

Heli-Coil

Location

Loc Qty

Loc Code

GA

130325

73

125097

5

m128537

68

ST301

50

m129499

50

9

Tuesday, July 22, 2014 8:44:12 AM

Shop Packet Print

Page 3

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FAULT CATEGORY

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Kim Johnston

From: Alan Stocker
Sent: Thursday, July 31, 2014 1:56 PM
To: Melanie Fauteux
Cc: Kim Johnston; Linda Lacelle; Marc Bellavance
Subject: RE: ECN 14-595

All parts in stock can be used as is. All new parts to be made going forward must comply.

Sorry I did my best to word it so you would understand clearly I have failed I hang my head in shame

Alan

From: Melanie Fauteux
Sent: Thursday, July 31, 2014 1:43 PM
To: Alan Stocker
Cc: Kim Johnston; Linda Lacelle
Subject: ECN 14-595

Hi Alan,

Quick question concerning this ECN. It says parts must comply but on the bottom of the description, it also says deplete existing stock of D4776-1/3.

So does that mean they're still good to use or they absolutely have to be reworked?

Thanks

Melanie

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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